

# Work Order ID 53482

November 6, 2009 8:42:13 AM



Page 1

Item ID: D3524-041  
Revision ID: A  
Item Name: Upper Plate Assembly

Accept



Setup Start



Stop



Start Date: 06/11/2009 Start Qty: 4.00  
Required Date: 13/11/2009 Req'd Qty: 4.00



Cost Item ID:

Customer:

Reference:

Approvals: Process Plan: PL Date: 09-11-13 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3524	Rev A								

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 3.700 " long

mw- 09/11/13

4

0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA700 Rev: AA & Dwg D3524 Rev: A ☐ 2-Deburr  
per dwg D3524

DIP 09/11/16

4

0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

DIP 09/11/16

4

0

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Start Date: 06/11/2009 Start Qty: 4.00  
Required Date: 13/11/2009 Req'd Qty: 4.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00				4	0		
140  Small Fab Small Fab Small Fab	Small Fab  Memo C'SINK AS PER DWG D3524	0.00  0.00							
150  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							

B.A 09/11/17

09/11/19

09/11/19

4

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Setup Start



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Stop



Item Name: Upper Plate Assembly

Start Date: 06/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

RIVET NUT PLATESAS PER DWG D3524

*EP 09/11/26* (Signature)

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*SB 09/11/27*

*4 0*

**Work Order ID 53482**

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Page 4

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Start Date: 06/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

Identify as per dwg & Stock Location: GK

0.00

8/5 09/11/27



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/27

PL0911-27  
(4)

# Picklist Print

November 6, 2009 8:42:18 AM

Page 1

Work Order ID: 53482

Parent Item: D3524-041RevA

Parent Item Name: Upper Plate Assembly


Start Date: 06/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD3-13  RIVET	091126	Purchased	No			100	Each	7,861.000	32.0000		09/11/26	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	7861	
104374	3861	
110398	4000	

M6061T6B0.375X03.00  
0

Purchased No

170

f

21.5800

1.2977



6061T6 BAR .375 X 3.00



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	21.58	
17887	13.75	
18237	7.83	

MS21075L06

Purchased No

170

Each

80.0000

16.0000



ANCHOR NUT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	80	
105978	80	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	53482
<b>Description:</b> Upper Plate		<b>Part Number:</b>	D3524-3
<b>Inspection Dwg:</b> D3524 Rev: A		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

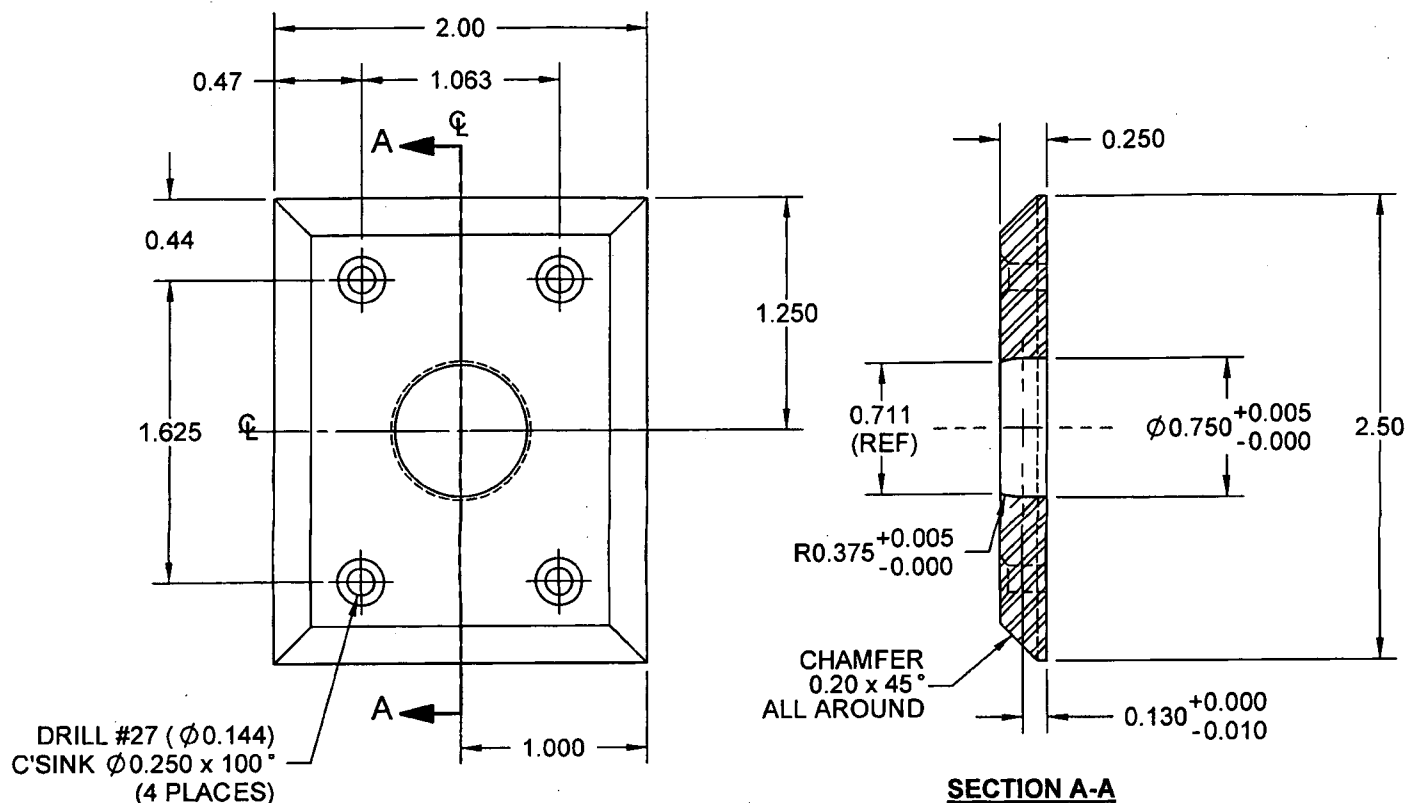
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	± 0.030	2.501	✓			
1.25	± 0.030	1.25	✓			
1.75	± 0.030	1.75	✓			
3.50	± 0.030	3.501	✓			
0.35	± 0.030	0.35	✓			
1.800	± 0.010	1.798	✓			
0.35	± 0.030	0.345	✓			
2.800	± 0.010	2.799	✓			
0.345	± 0.010	0.344	✓			
0.210	± 0.005	0.205	✓			
R0.375	+0.005/-0.000	0.375	✓			
0.075	± 0.010	0.074	✓			
0.270	± 0.010	0.270	✓			REF
0.750	± 0.010	0.746	✓			REF
0.218	± 0.010	0.218	✓			TYP
Ø 0.129	+0.005/-0.010	0.129	✓			4 Places
Ø 0.144	+0.005/-0.010	0.145	✓			4 Places
Ø 0.098	+0.004/-0.001	0.098	✓			8 Places
Ø 0.673	± 0.010	0.675	✓			
1.063	± 0.010	1.063	✓			
0.72	± 0.030	0.72	✓			
0.94	± 0.030	0.94	✓			
1.625	± 0.010	1.624	✓			
0.375	± 0.010	0.373	✓			TYP
Measured by: DJP	Audited by: J.A.		Prototype Approval:		N/A	
Date: 09/11/16	Date: 09/11/17		Date:		N/A	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

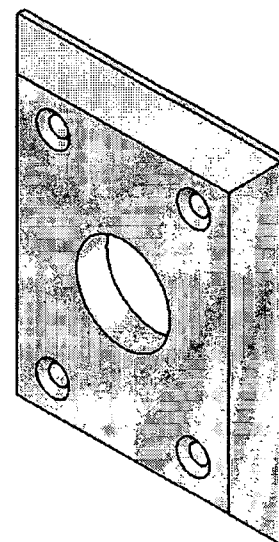
P10 D3524-041

**DART**

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED H	DRAWING NO. D3524	REV. A SHEET 1 OF 3
DATE 07.07.24	TITLE UPPER AND LOWER PLATE		SCALE 1:1
REV A	DATE 07.07.24	DESCRIPTION NEW ISSUE	



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WORK ORDER NO. 53482  
B/09-1-5

**D3524-1 LOWER PLATE****RELEASED**  
07.08.03**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART SYMMETRIC ABOUT  $\phi$

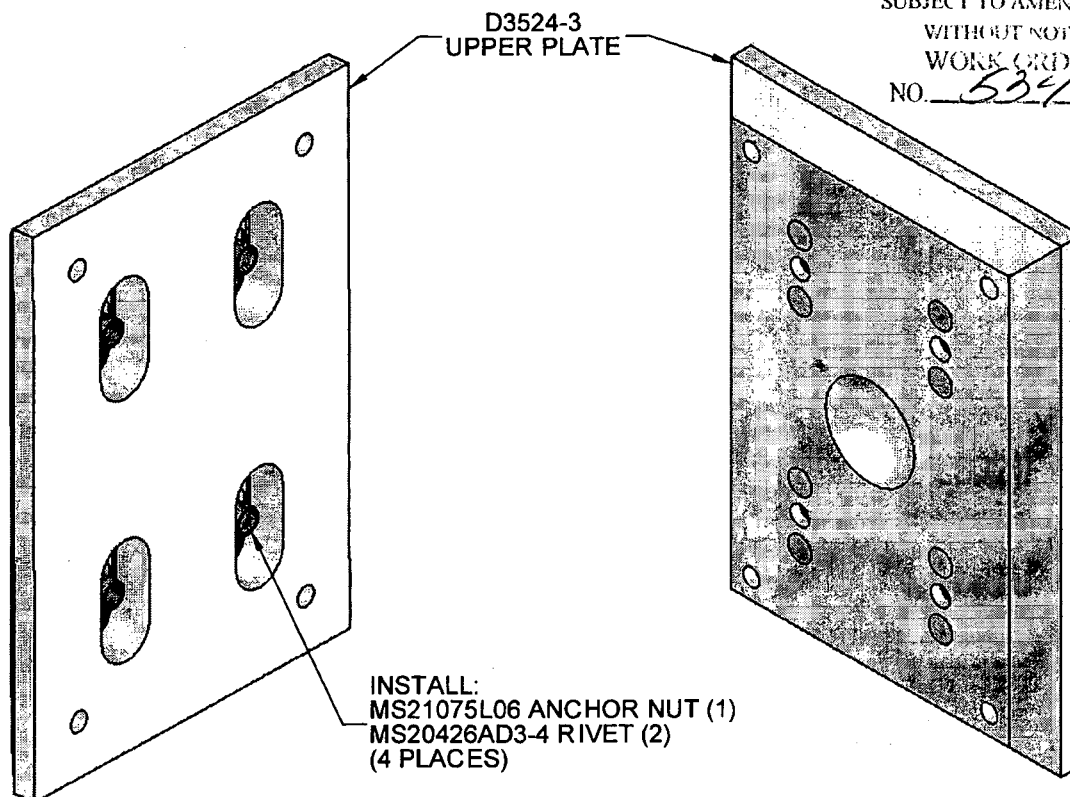
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**DART**

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CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3524</b>	REV. A SHEET 2 OF 3
DATE <b>07.07.24</b>		TITLE <b>UPPER AND LOWER PLATE</b>	SCALE 1:1

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WORK ORDER  
NO. *53482*

**D3524-041 UPPER PLATE ASSEMBLY**

**RELEASED**  
07-08-03 *[Signature]*

**PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D3524-041	UPPER PLATE ASSEMBLY
1	D3524-3	UPPER PLATE
4	MS21075L06	ANCHOR NUT
8	MS20426AD3-4	RIVET

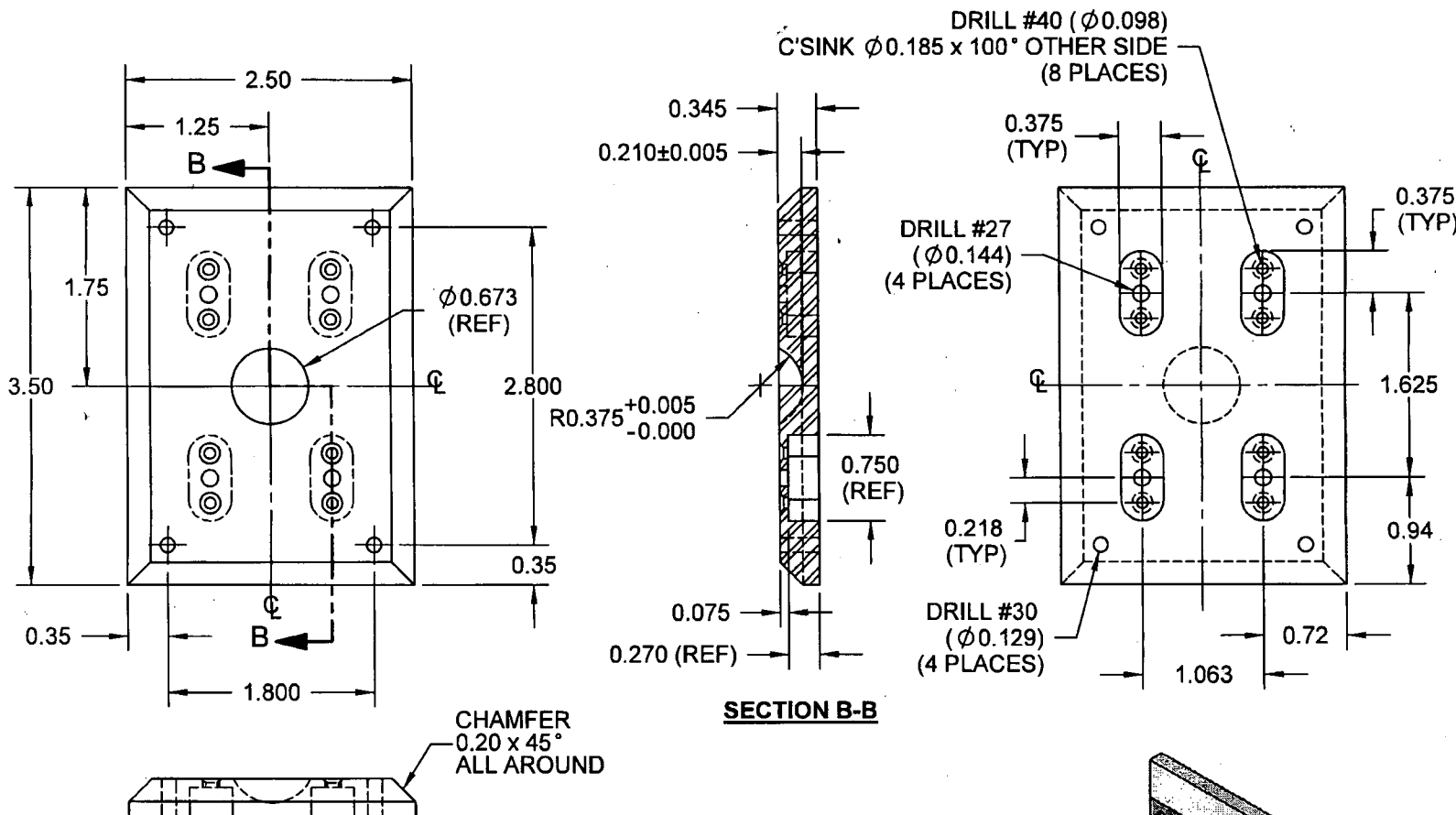
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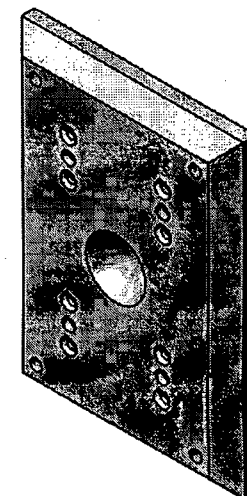
DESIGN	CB	DRAWN BY	CB	DART AEROSPACE LTD
CHECKED	LE	APPROVED	[Signature]	HAWKESBURY, ONTARIO, CANADA
DATE	07.07.24	TITLE	D3524	REV. A
			UPPER AND LOWER PLATE	SHEET 3 OF 3
				SCALE 2:3



# **D3524-3 UPPER PLATE**

## **NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART SYMMETRIC ABOUT  $\phi$



*W/O 53482*

**RELEASED**

07.08.03

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